

Work Order ID 128284

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SHIP FRIDAY JAN 16 LATEST

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Item ID: D3136-045

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Window Assembly

Stop *NS2*

Start Date: 1/13/15 Start Qty: 16.00

16

Cust Item ID:

Required Date: 1/15/15 Req'd Qty: 16.00

16

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3136

F

100

0.00

100

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg

Dwg Rev: F

Prog Rev: F

2-Deburr if necessary

Plexiglas G. 125"
Clear.

17 0 Jm 15-1-14

110

0.00

110

QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

17 0 Jm 15-1-14

120

0.00

120

QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

15 2

DAS
07
9-89

15/01/14
PTO.

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Item ID: D3136-045 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Window Assembly
 Start Date: 1/13/15 Start Qty: 16.00 ***16*** Cust Item ID:
 Required Date: 1/15/15 Req'd Qty: 16.00 ***16*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							DAS 07 9-89
130	THERMOFORMING MACHINE					15			15/01/15
Thermoform	Memo	0.00							
Thermoforming Machine	1-Thermoform as per Dwg D3136 and Work Instruction WI006								
	Dwg Rev. <u>F</u>								
	WI Rev. <u>D</u>								
	2- Engrave Part # and Batch # , and affix labels (D3108-9)								
150		0.00							DAS 07 9-89
150	HAND FINISHING THERMOFORMING					15			15/01/15
HandThermo	Memo	0.00							
Hand Finishing Thermoforming	Water sand and buff to remove scratches as required								

Picklist Print

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Work Order ID: 128284

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Parent Item: D3136-045

D3136-045

Parent Item Name: Window Assembly

Start Date: 1/13/15

Required Date: 1/15/15

Start Qty: 16.00

Required Qty: 16.00

Comments: IPP REV:C 15.02.13 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D3108-9		Manufactured	No				Each	389.0000		32			
D3108-9									**				DAS
Decal													07
													9-89

15/01/15

MACRLICS.125

Purchased

No

Location

ST017

46546

Loc Qty

389

389

sf

Loc Code

139.0000

30

96

Jm 15-1-14

MACRI ICS 125

1/8" Polycast II Sheet

Location

MAT019

m130047

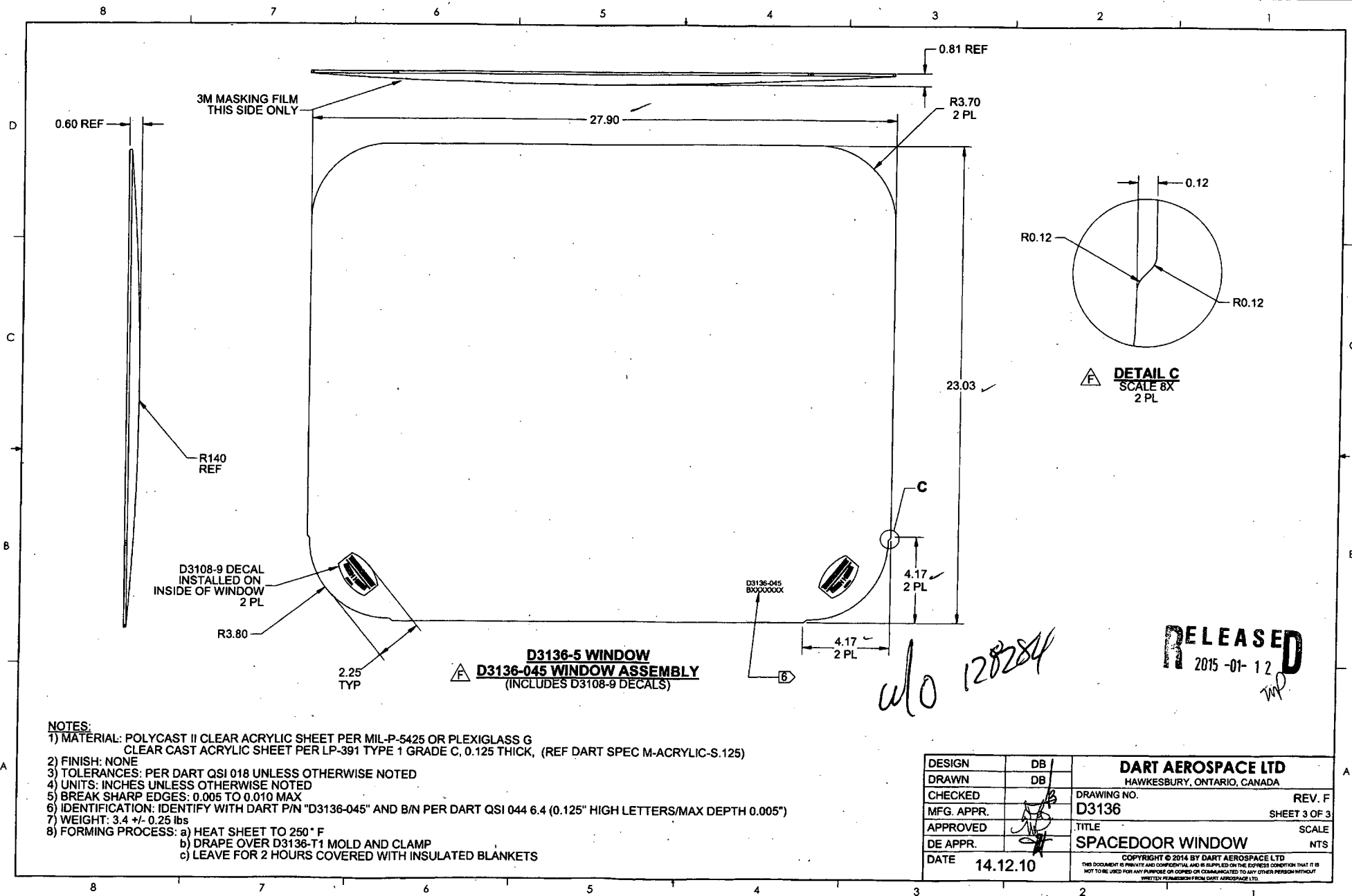
Loc Qty

139

139

Loc Code

130047



NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: AK Date: 15/01/14QA Closed: AK Date: 15/06/24

Work Order: <u>128284</u> Part No. <u>D3136-045</u> <u>15-5135</u> NCR No. <u>15-5136</u>				DISPOSITION Rework ☐ Scrap ☒ Use-as-is ☐ Work Order Update ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Crosstube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☒ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
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Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data	15/01/14	120	1	Deep scratch through MASKING. SMALL HOLE DRILLED THROUGH MASKING INTO SHEET. P.C. make Operator not paying attention on is his work and not second checking before passing to next operator.	 15/06/19 azou2	Scrap 1 part. INSTRUCT OPERATOR TO INSPECT FOR TEARS IN MASKING. SAME AS ABOVE. Scrap 1 part.	Wh 15/01/14 Wh 15/01/14	38 9-88 JAN 16 2015	DAS 9 9-88 15-01-16
Equip/Tooling									
Operator	15/01/14	120	1						
Material									
Setup									
Other									
Process									
Supplier									
Training									
Unapproved									

before passing to next operator **FAULT CATEGORY** ☒

Landing Gear ☐ Bending ☐ Centre Not Concentric to O/S ☐ Cracks ☐ Crushed/Crimped ☐ Cuffs ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Ripples in Bend ☐ Torque Waves in Extrusion ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☒ BOM/Route ☒ Broken/Damaged ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drill Holes ☐ Drawing ☐ Finish ☐ Folio	☐ Grain ☐ Hardware ☐ Inspection Incomplete ☐ Instructions Incomplete/Unclear ☐ Maintenance ☐ Mislabeled ☐ Misread ☐ Offset ☐ Out of Calibration ☐ Out of Sequence ☐ Outside Dimensions
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☐ Ovalized ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge	☐ Pressure/Forced ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled	☐ Other ☐ ☐ ☐
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